

Work Order ID 58065



Page 1

April 22, 2010 2:18:40 PM

Item ID: D4048-041

Revision ID:

**Item Name:** Mounting Lug Assembly, LH

Start Date: 4/22/10 Start Qty: 2.00

**Required Date:** 4/30/10      **Req'd Qty:** 2.00

### Reference:

### Approvals:      Process Plan:

Date: 10-4-22 Tooling:

**Cust Item ID:**

**Customer:**

## Setup Start



Stop



A standard 1D barcode is located in the bottom right corner of the page.

Date:

### Run Start



Stop



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 58065**

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April 22, 2010 2:18:41 PM

Item ID: D4048-041

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug Assembly, LH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

**Sequence ID/  
Work Center ID**
**Operation  
Description**
Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/12 HJ  
MF 10-5-12

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NOTE: Date & initial all entries

# Picklist Print

April 22, 2010 2:18:39 PM

Page 1  
J

Work Order ID: 58065



Parent Item: D4048-041



Parent Item Name: Mounting Lug Assembly, LH

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP Rev:A as per dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-14A



Bolt

Purchased

No

100

Each

129.0000

4.0000

H114582



(4)

SB 10/05/10

(2)

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST358

129

113359

129

AN960JD416



Washer

Purchased

No

100

Each

0.0000

4.0000

H114576



(4)

SB 10/05/10

(2)

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

B58 078

1

ST468

1

D4048-3



Mounting Lug

Manufactured

No

100

Each

1.0000

2.0000



2

SB 10/05/10

(2)

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

B58 079

1

ENG

1

Mounting Lug

(2)

SB 10/05/10

(2)

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Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP Rev:A as per dwg revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4048-9 		Manufactured		No		100	Each	0.0000	8.0000			
Bushing 		Purchased		No		100	Each	1,364.000	4.0000			
MS21042L4 												
Nut												

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse ST139	2	
	111827	
Main Warehouse ST300	862	
	113422	
	114108	
	9063	
Main Warehouse ST463	500	
	114416	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

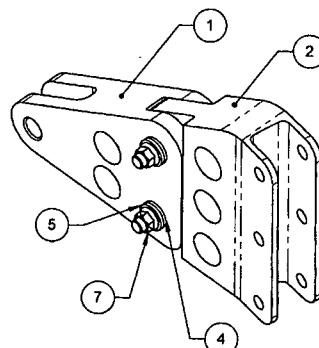
D

C

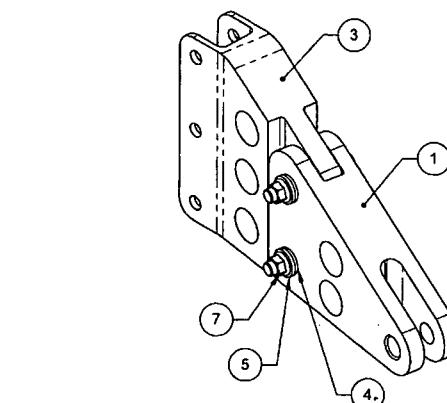
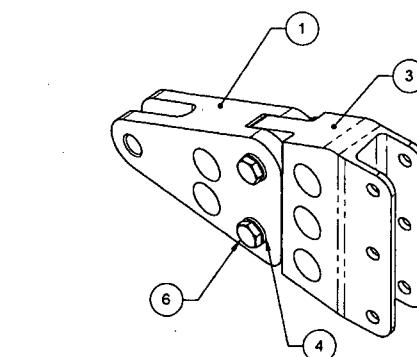
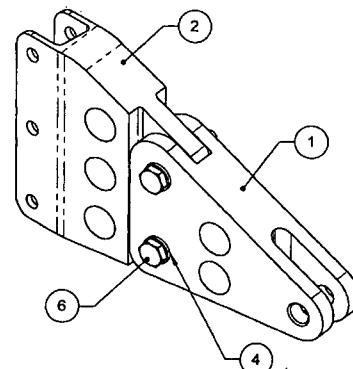
C

B

B



D4048-041 MOUNTING LUG ASSY (SHOWN)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4048-041/-042: 1.16 lbs
- 8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)

ITEM	QTY -041	QTY -042	P/N	Description
	X		D4048-041	MOUNTING LUG ASSY
		X	D4048-042	MOUNTING LUG ASSY
1	1	1	D4048-1	MOUNTING LUG
2	1		D4048-3	MOUNTING LUG
3		1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960JD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 58065

130-4-22

RELEASED  
2010-07-16  
MP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	
MFG. APPR.	90	D4048	REV. A
APPROVED	90	SHEET 1 OF 9	
DE APPR.	90	TITLE	SCALE
DATE	10.01.29	MOUNTING LUG ASSY	NTS

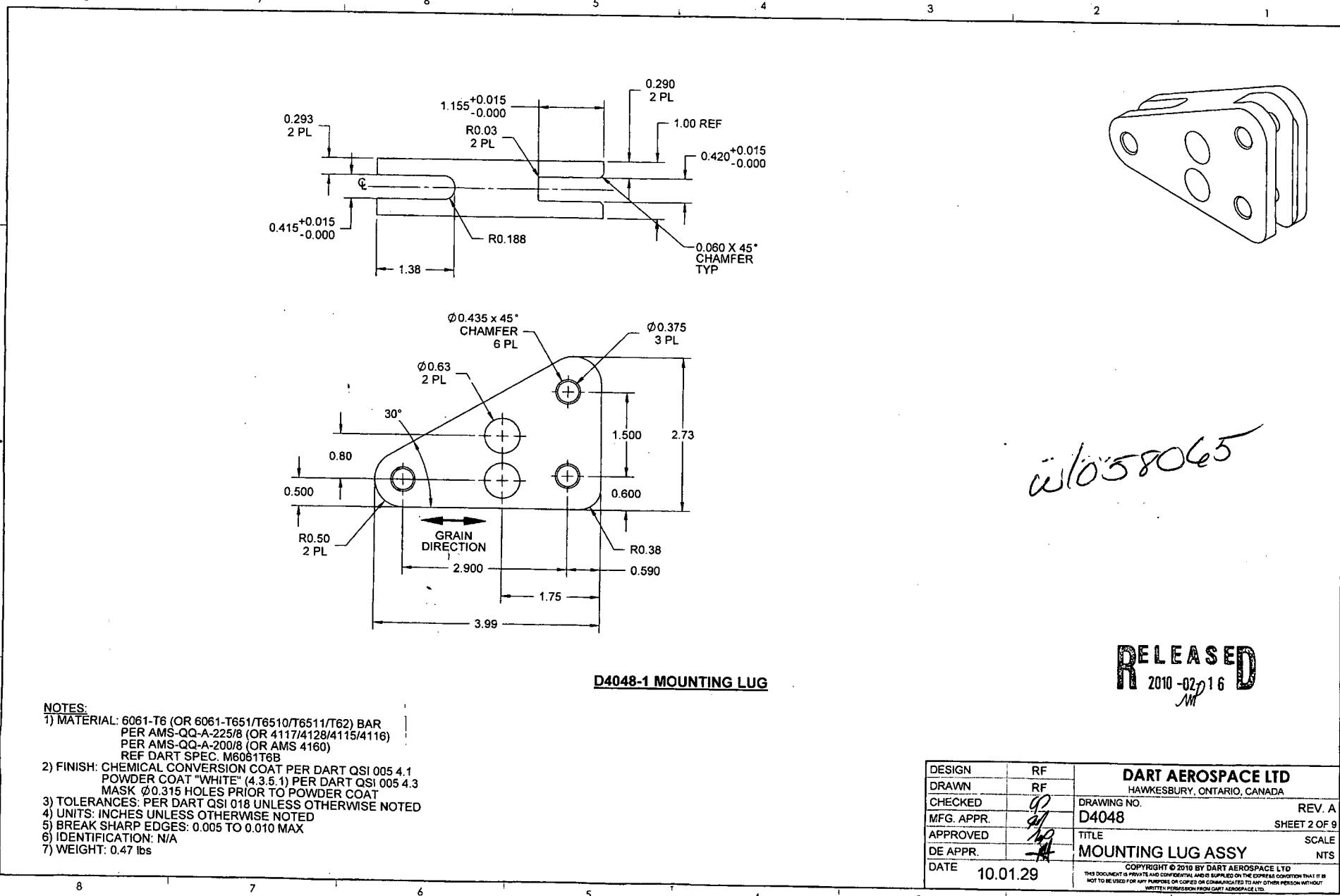
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NOTE: Date & initial all entries



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99		
MFG. APPR.	99	REV. A	
APPROVED	99	SHEET 2 OF 9	
DE APPR.	99	TITLE	SCALE
DATE	10.01.29	Mounting Lug Assy	NTS

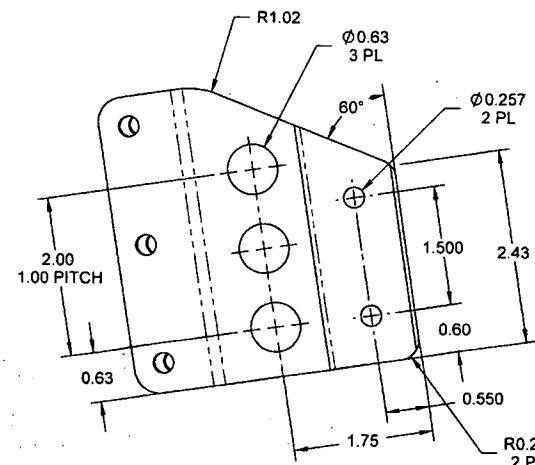
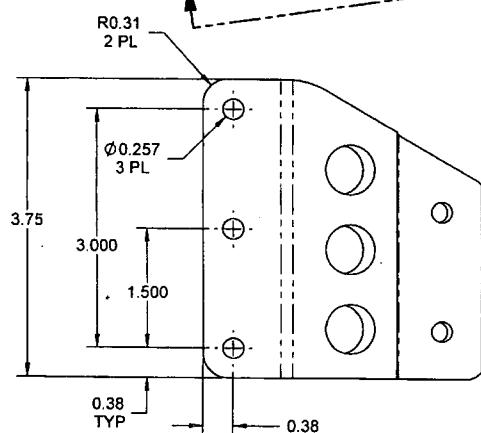
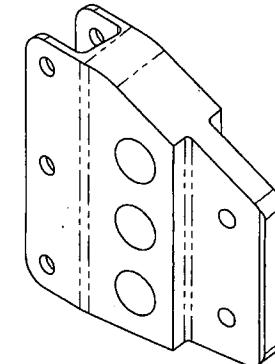
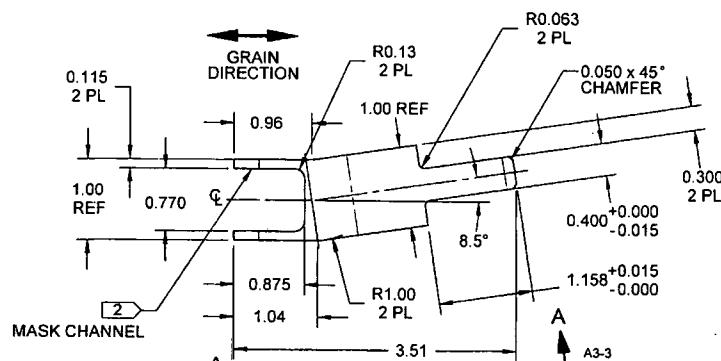
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WLO 580d.8

VIEW A-A C5-3

RELEASED  
2010-02-16  
MP

#### NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6081T6B  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
MASK Ø 0.257" HOLES AND INDICATED CHANNEL (ZN C7-3)  
PRIOR TO POWDER COAT  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.61 lbs

### **D4048-3 MOUNTING LUG**

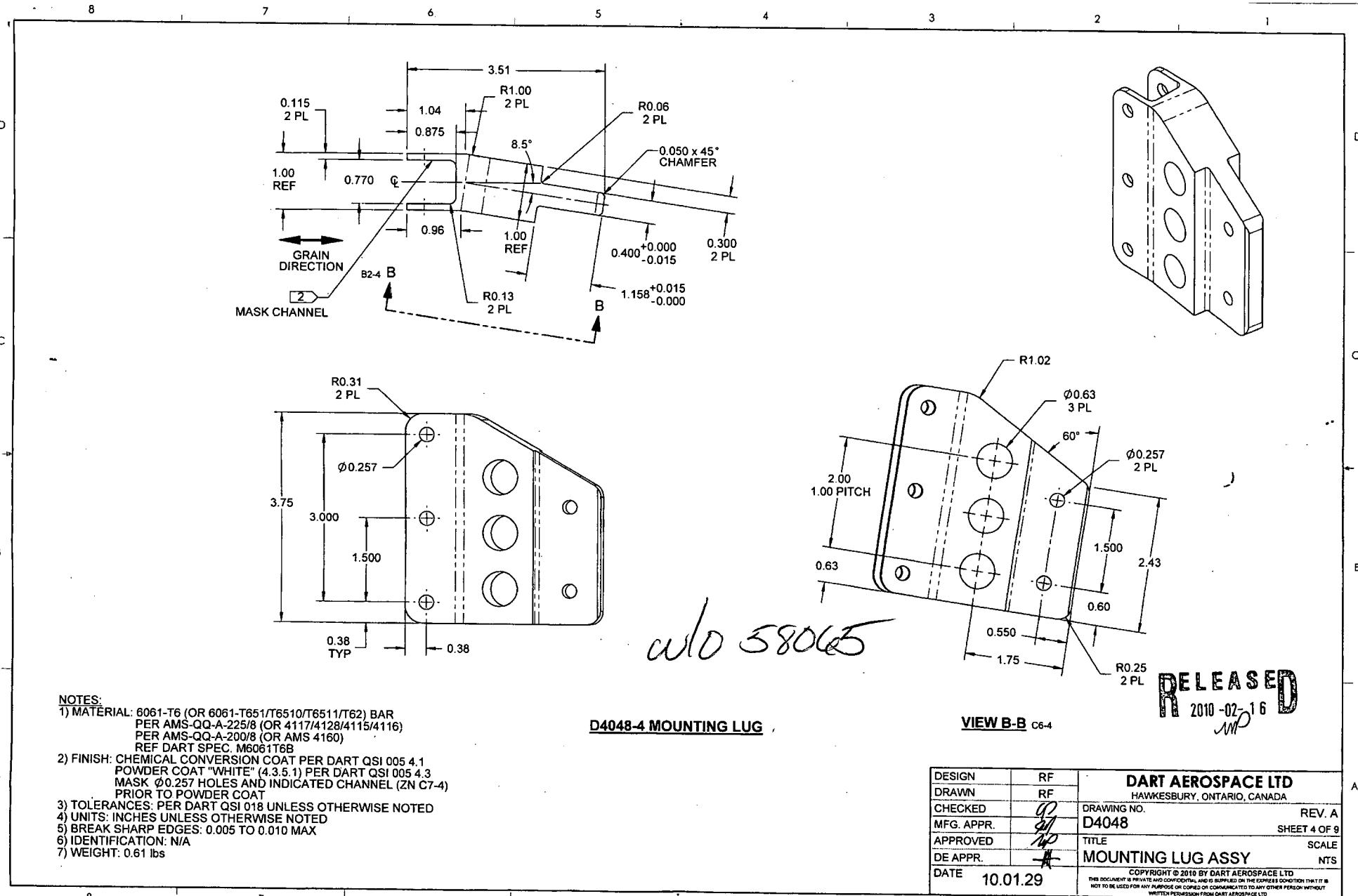
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DRAWN	RF			
CHECKED	<i>99</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>99</i>	D4048		
APPROVED	<i>100</i>	TITLE	SCALE NTS	
DE APPR.	<i>100</i>	Mounting Lug Assy		
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.		

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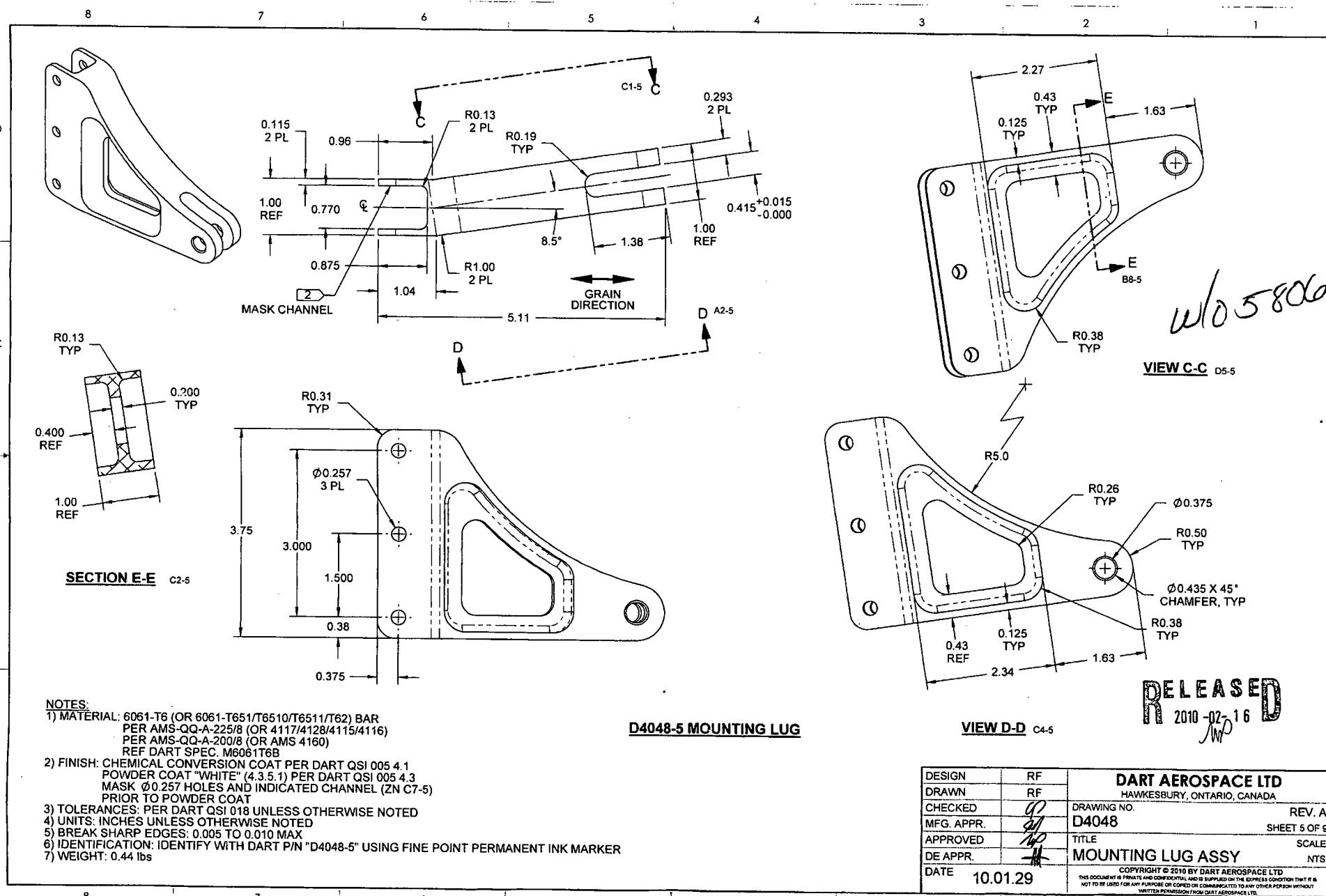


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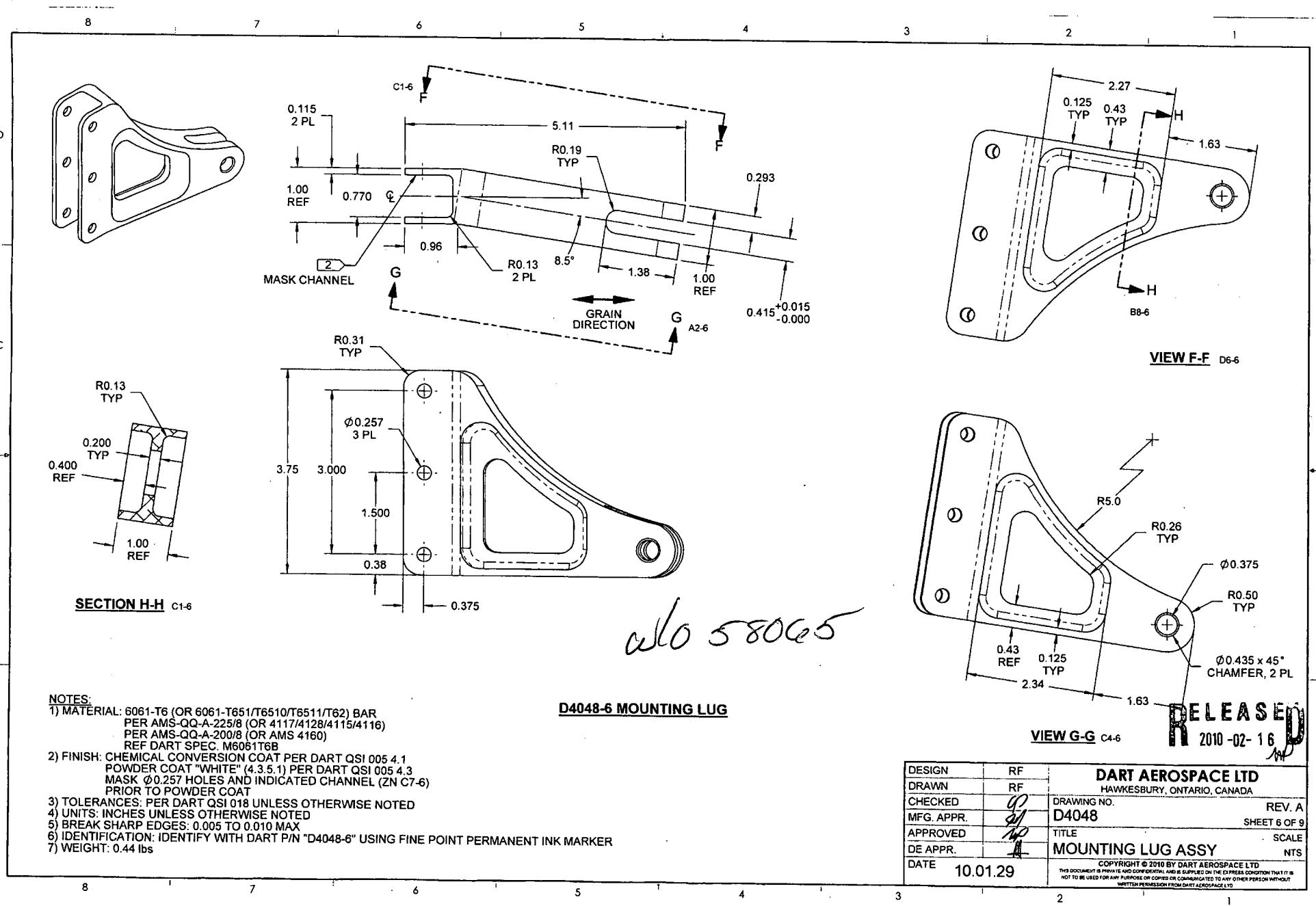


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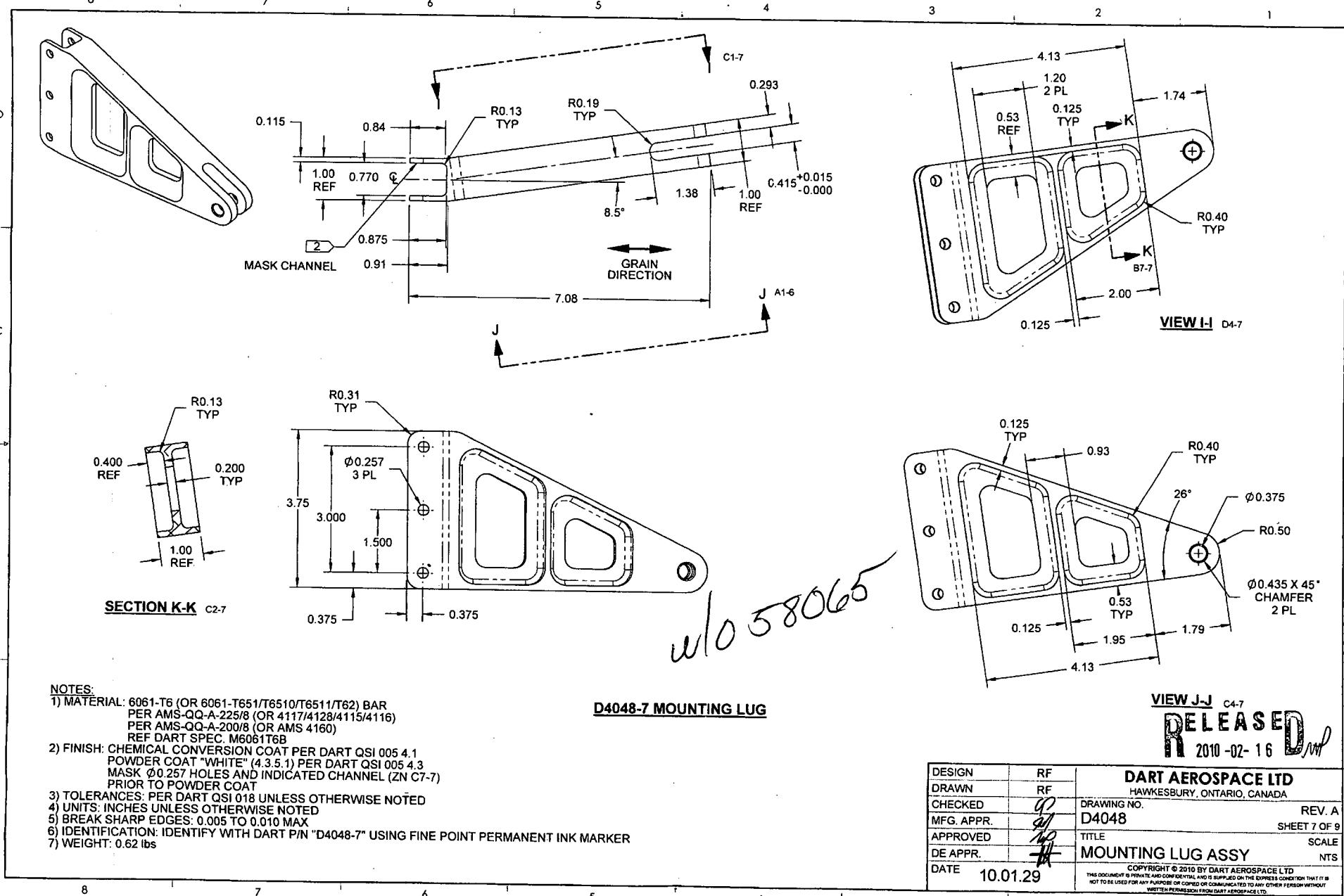


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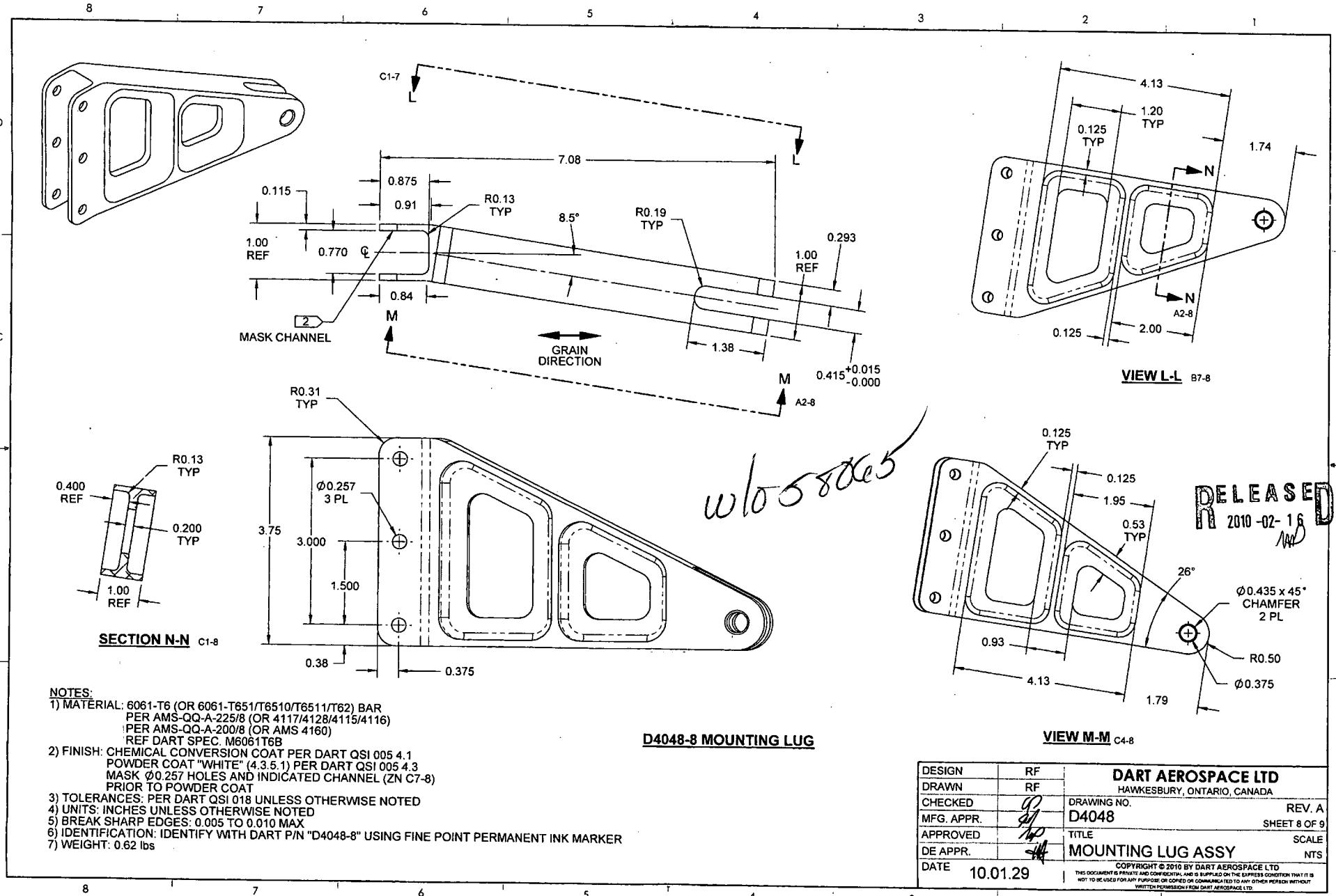


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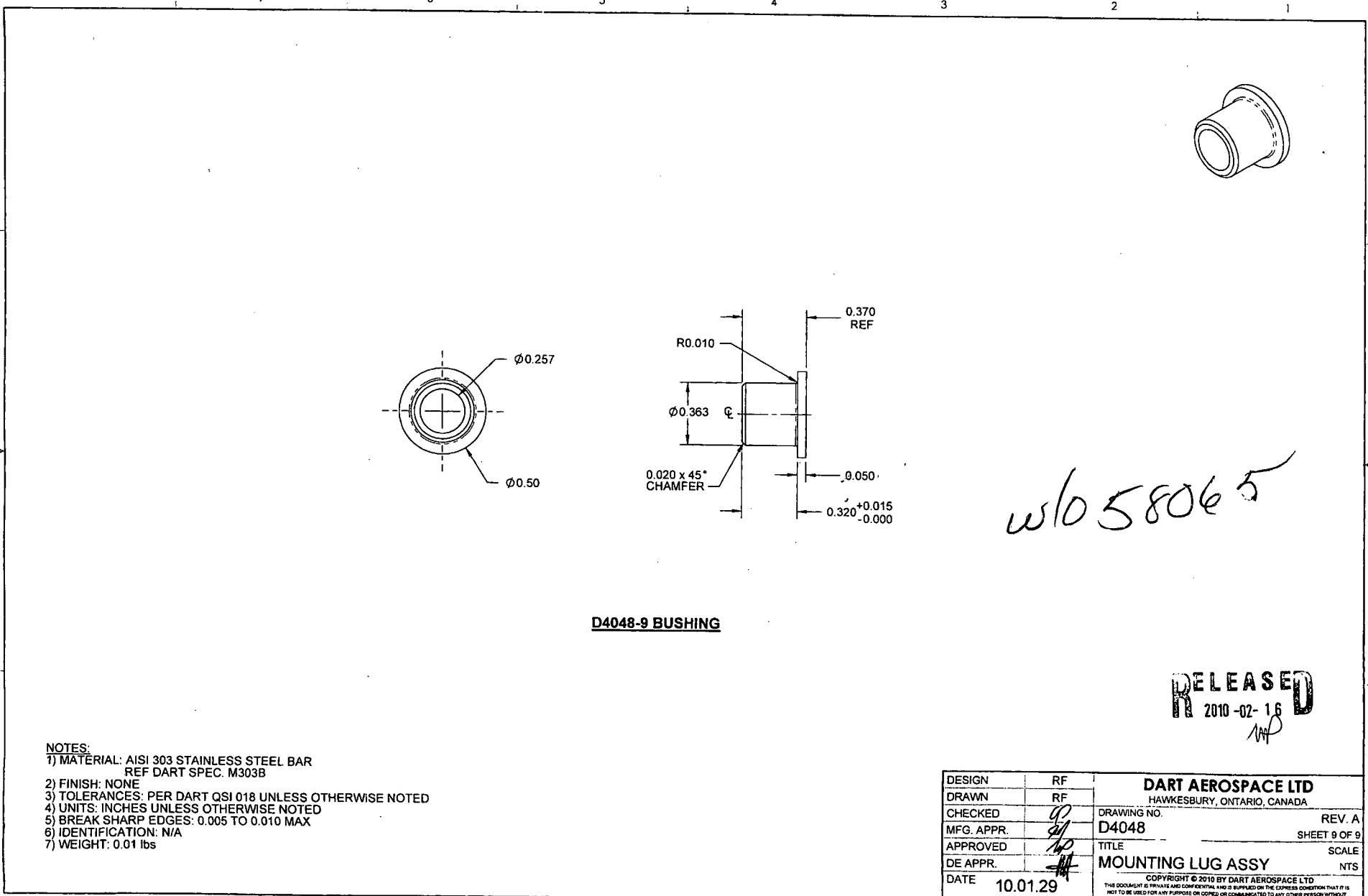


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**L Lacelle**

**From:** Jean-Luc Menard [jmenard@dartaero.com]  
**Sent:** May 7, 2010 10:23 AM  
**To:** L Lacelle  
**Subject:** FW: D4048-9 bushing - USFS basket

**From:** Mike Petsche [mailto:mpetsche@dartaero.com]  
**Sent:** May 7, 2010 10:05 AM  
**To:** 'Jean-Luc Menard'  
**Subject:** FW: D4048-9 bushing - USFS basket

**From:** Robert Fuentes [mailto:rfuentes@dartaero.com]  
**Sent:** May 7, 2010 10:06 AM  
**To:** 'Mike Petsche'  
**Cc:** 'David Shepherd'  
**Subject:** RE: D4048-9 bushing - USFS basket

Hi Mike,

That was done in purpose to no over stress clamp and help on the alignment basket in hard point in the aircraft. We notice that in the installation for flight test, didn't produce a concern, because everything was secure and no movement between this two parts.

Roberto

**From:** Mike Petsche [mailto:mpetsche@dartaero.com]  
**Sent:** Friday, May 07, 2010 6:43 AM  
**To:** 'Robert Fuentes'  
**Cc:** 'David Shepherd'  
**Subject:** D4048-9 bushing - USFS basket

Roberto,

Could you double check the length of these bushings? Sylvie is trying to assemble the basket mounts. She discovered that the bushings as they are are too long to allow the bolts the secure the mounts correctly. Essentially the bushing are bottoming out. They seem to be about .030" too long.

Could you please take a quick look?

Thanks

**Mike Petsche**  
DART Aerospace  
Design Manager  
  
613-632-5200  
514-833-1657

No virus found in this incoming message.  
Checked by AVG - [www.avg.com](http://www.avg.com)  
Version: 9.0.819 / Virus Database: 271.1.1/2858 - Release Date: 05/07/10 02:26:00